

5/51

DART AEROSPACE LTD	Work Order:	24085
Description: Long Step Assembly – High Skid, LH	Part Number:	D350-591-311
Dwg: D3272 Rev. A	Qty:	10
Page 1 of 2		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	HA	05.08.23	10
2	DC	Photocopy bluefile and type labels as per PPP D350-591-311 CHG001	K.S.	05-12-09	10
3	GA	Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A Pick: Qty Part Number Description Batch 1 D2622-120C Extrusion 324092	KE	06.01.13	10
4	GA	Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.	KE	06.01.16	10
5	GA	Deburr	KE	06.01.16	10
6	QC5	Inspect work to Step 5	2	06.01.16	10
7	WA	Bevel end for welding FWD ONLY	KE	06.01.16	10
8	WA	Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 Pick: Qty Part Number Description Batch 1 D3067-1 End Plate 324566 2 D3219-1 Support 324507 A/R Aluminum Rod M18834	KE	06.01.16	10
9	GA	Grind End Plate flush	KE	06.01.17	3
10	QC9 & 5	Inspect weld and work to Step 9	PD	06.02.01	10
11	FP	Chemical conversion coat as per QSI 005 4.1	FF	06.02.01	10
12	GA	Assemble Leg Assembly as per Dwg D3272. (D3066-1 is part of D3065-041 Step Leg Assembly, do not add to BOM.) Pick: Qty Part Number Description Batch 1 D3065-041 Step Leg Assy 324093 2 D3066-1 Spacer 323618 16 MS20600AD4W4 Rivet M18359	KE	06.02.14	10
13	QC5	Inspect work to step 12	PD	06.02.06	10
14	WA	Bevel Aft end for welding	KE	06.02.06	10
15	WA	Inspect for foreign object as per QSI 024	KE	06.02.06	10
16	WA	Weld Aft End Plate as per QSI 004 & Dwg D3272 Pick: Qty Part Number Description Batch 1 D3067-1 End Plate 324566 A/R Aluminum Rod M18834 Identify as D3272-041	KE	06.02.06	10

RELEASED
04.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: SD Date: 06/03/01

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	24085
Description: Long Step Assembly – High Skid, LH		Part Number:	D350-591-311
Dwg: D3272 Rev. A		Qty:	10
		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty																																																																
17	GA	Grind End Plate flush	FF	06-02-08	10																																																																
18	QC9 & 5	Inspect work to Step 17 – Check dimension 108.93" & 3.375" as per Dwg D3272	PD	06-02-08	10																																																																
19	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	g.m	06-02-11	10																																																																
20	FP	Wing Walk as per Dwg D3272 and QSI 005 4.4	a.m	06-02-20	10																																																																
21	QC3	Inspect Powder Coat and Wing Walk	cl	06/02/27	10																																																																
22	KP	<p>Pick: Packing Kit (Note: D3272-041 is on BOM as material listed in Step 3)</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>✓4</td><td>D2230-3</td><td>Mounting Lug</td><td>B24399</td></tr><tr><td>✓2</td><td>D2618</td><td>Bushing</td><td>B23697</td></tr><tr><td>✓2</td><td>D2856-400-720</td><td>Abrasion Strip</td><td>B24237A</td></tr><tr><td>✓2</td><td>D3235-1</td><td>Mounting Lug 1/2 X 1/2</td><td>B24409/4X B22123E</td></tr><tr><td>1</td><td>D3272-041</td><td>Step Assembly</td><td>B24085</td></tr><tr><td>1</td><td>D3278-041</td><td>Support Assembly</td><td>B24568</td></tr><tr><td>2</td><td>AN3-35A</td><td>Bolt</td><td>m17944</td></tr><tr><td>8</td><td>AN4-13A</td><td>Bolt</td><td>65 x m 18917/15 x m 18369</td></tr><tr><td>✓2</td><td>AN5-36A</td><td>Bolt</td><td>8 x m 11492/12 x m 16114</td></tr><tr><td>4</td><td>✓AN960JD10</td><td>Washer</td><td>20 x m 15321/20 x m 19413</td></tr><tr><td>✓6</td><td>AN960JD416</td><td>Washer</td><td>m19085</td></tr><tr><td>✓4</td><td>AN960JD516</td><td>Washer</td><td>8 x m 10765/32 x m 15006</td></tr><tr><td>✓2</td><td>MS21042L3 ✓</td><td>Nut (or -3)</td><td>m15066</td></tr><tr><td>✓8</td><td>MS21042L4 ✓</td><td>Nut (or -4)</td><td>m17997</td></tr><tr><td>✓2</td><td>MS21042L5 ✓</td><td>Nut (or -5)</td><td>m19073</td></tr></tbody></table>	Qty	Part Number	Description	Batch	✓4	D2230-3	Mounting Lug	B24399	✓2	D2618	Bushing	B23697	✓2	D2856-400-720	Abrasion Strip	B24237A	✓2	D3235-1	Mounting Lug 1/2 X 1/2	B24409/4X B22123E	1	D3272-041	Step Assembly	B24085	1	D3278-041	Support Assembly	B24568	2	AN3-35A	Bolt	m17944	8	AN4-13A	Bolt	65 x m 18917/15 x m 18369	✓2	AN5-36A	Bolt	8 x m 11492/12 x m 16114	4	✓AN960JD10	Washer	20 x m 15321/20 x m 19413	✓6	AN960JD416	Washer	m19085	✓4	AN960JD516	Washer	8 x m 10765/32 x m 15006	✓2	MS21042L3 ✓	Nut (or -3)	m15066	✓8	MS21042L4 ✓	Nut (or -4)	m17997	✓2	MS21042L5 ✓	Nut (or -5)	m19073			
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23	QC4	Inspect Kit 100% for Completeness on the W/O	CL	06/02/27	10																																																																
24	PK	Package for shipping as per PPP D350-591-311 REV B		6/2/27	10																																																																
25	AC	Cost / part		6/2/28	10																																																																
26	DC	Close W/O Inspect Level 21		06-03-01	10																																																																

Rev	Date	Change	Revised By	Approved
A	04.03.22	New issue	KJ/RF	

RELEASED
04.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 18, 2005
10:59 am

Work Order No : 0024085
Project Name : D350-591-311
Project For : WK551
Work Order Type : Main
Main WO Number :
House Part Number : *D350-591-311
Description : Heli-Access-Step, LH Hi
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 08-16-05
Est Finish Date : 12-22-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:51 am

Work Order No : 0024085
Project Name : D350-591-311
Project For : WK551
Work Order Type : Main
Main WO Number :
House Part Number : *D350-591-311
Description : Heli-Access-Step, LH Hi
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 08-16-05
Est Finish Date : 12-22-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

*M/S open bz1
W*
11-11

Date: Wednesday, 11/9/2005 1:04:18 PM
User: Linda Lacelle









Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LONG STEP ASSEMBLY HIGH SKID LH
Job Number :	24085		
Estimate Number :	10270		
P.O. Number :		Part Number :	D350591311
This Issue :	11/9/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3272 REV A
First Issue :	/ /	Project Number :	
Previous Run :	24083	Drawing Revision :	A
		Material :	
Written By :		Due Date :	11/30/2005
Checked & Approved By :		Qty:	10
Comment :	Est Rev:A 04.03.22 New issue KJ/RF		
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
 		
Comment: DOCUMENT CONTROL Photocopy bluefile and type labels as per PPP D350-591-311 CHG001		
2.0	D2622120C	Extrusion
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
 		
Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A 2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets. 3-Deburr		
4.0	QC5	INSPECT WORK TO CURRENT STEP
 		
Comment: INSPECT WORK TO CURRENT STEP		
5.0	D30671	End Plate
6.0	D32191	Support
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
 		
Comment: LARGE FABRICATION RESOURCE 1 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____		

User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 24085

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Grind End Plate flush

8.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 9

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

D3065041

Step Leg Assembly

12.0

D30661

Spacer

13.0

MS20600AD4W4

Rivets

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

D30671

End Plate

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod _____

4-Grind End Plate flush

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 24085

Part Number: D350591311

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0

QC5/9

WELD INSPECTION



Comment: Inspect work & Weld to Current - Check dimension 108.93" & 3.375" as per Dwg D3272

19.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

21.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

23.0

D22303

Mounting Lug

24.0

D2618

Bushing

25.0

D2856400720

Abrasion Strip

26.0

D32351

Mounting Lug

27.0

D3272041

Step Assembly

28.0

D3278041

Support Assembly

29.0

AN335A

Bolt

30.0

AN413A

Bolt

31.0

AN536A

BOLT

32.0

AN960JD10

Washer

33.0

AN960JD416

Washer

34.0

AN960JD516

Washer

35.0

MS21042L3

Nut

36.0

MS21042L4

Nut

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 24085

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

MS21042L5

Nut

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-311

Location: _____

40.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

